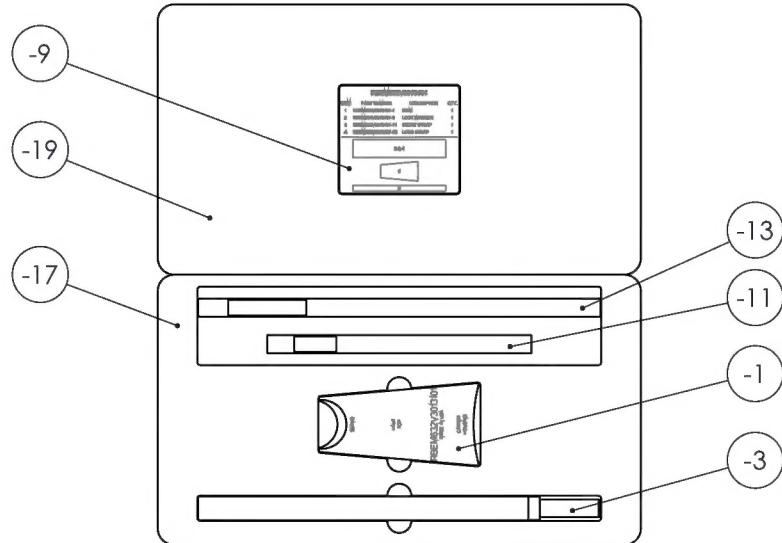


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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.			11/3/2016	DPD	JAG



NOTE:  
REF. AIRBUS T/N: RBEM632V3013101.

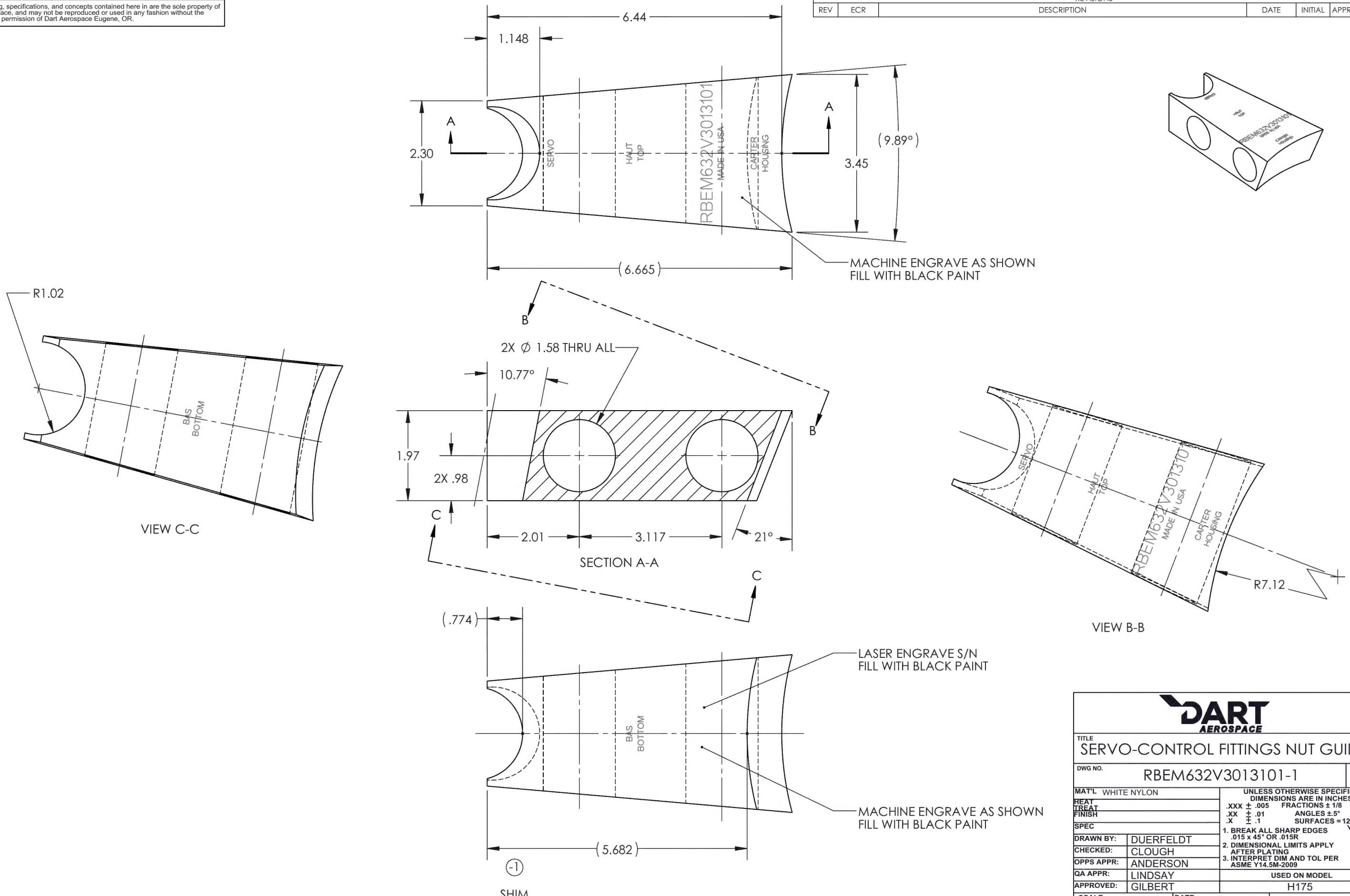
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SHIM	WHITE NYLON		2
X			-3	1	LOCK WRENCH			3
1			-5	1	ROD	1018/1020 CR		4
1			-7	1	COVER	6061		5
			-9	1	PLACARD	PLASTIC		6
B/O		-11	1	1	SHORT STRAP	NYLON	(OLYMPIC SYNTHETICS)	7
B/O		-13	1	1	LONG STRAP	NYLON	(OLYMPIC SYNTHETICS)	8
1	B/O	-15		1	SPRING PIN	STEEL	M3 X 22mm (MCMASTER-CARR #91611A160)	3
	B/O	-17	1	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	5.79 X 11.26 X 20.12 (CASE SOLUTIONS)	9
	B/O	-19	1	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.79 X 11.26 X 20.12 (CASE SOLUTIONS)	10
	B/O	-21	1	1	CASE	PLASTIC	PELICAN #APP-1510-E	N/S
	B/O		1	1	PLACARD	ALUMINUM	RB41011	N/S
	ASSY -3							

TITLE		REV	
SERVO-CONTROL FITTINGS NUT GUIDE		1	
DWG NO.	RBEM632V3013101		1
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5°	
FINISH		X ± .1 SURFACES = 125	
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:		DUERFELDT	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		USED ON MODEL GILBERT H175	
SCALE 1:8		DATE 6/14/2016	
SHEET 1 OF 10			

**DART**  
AEROSPACE

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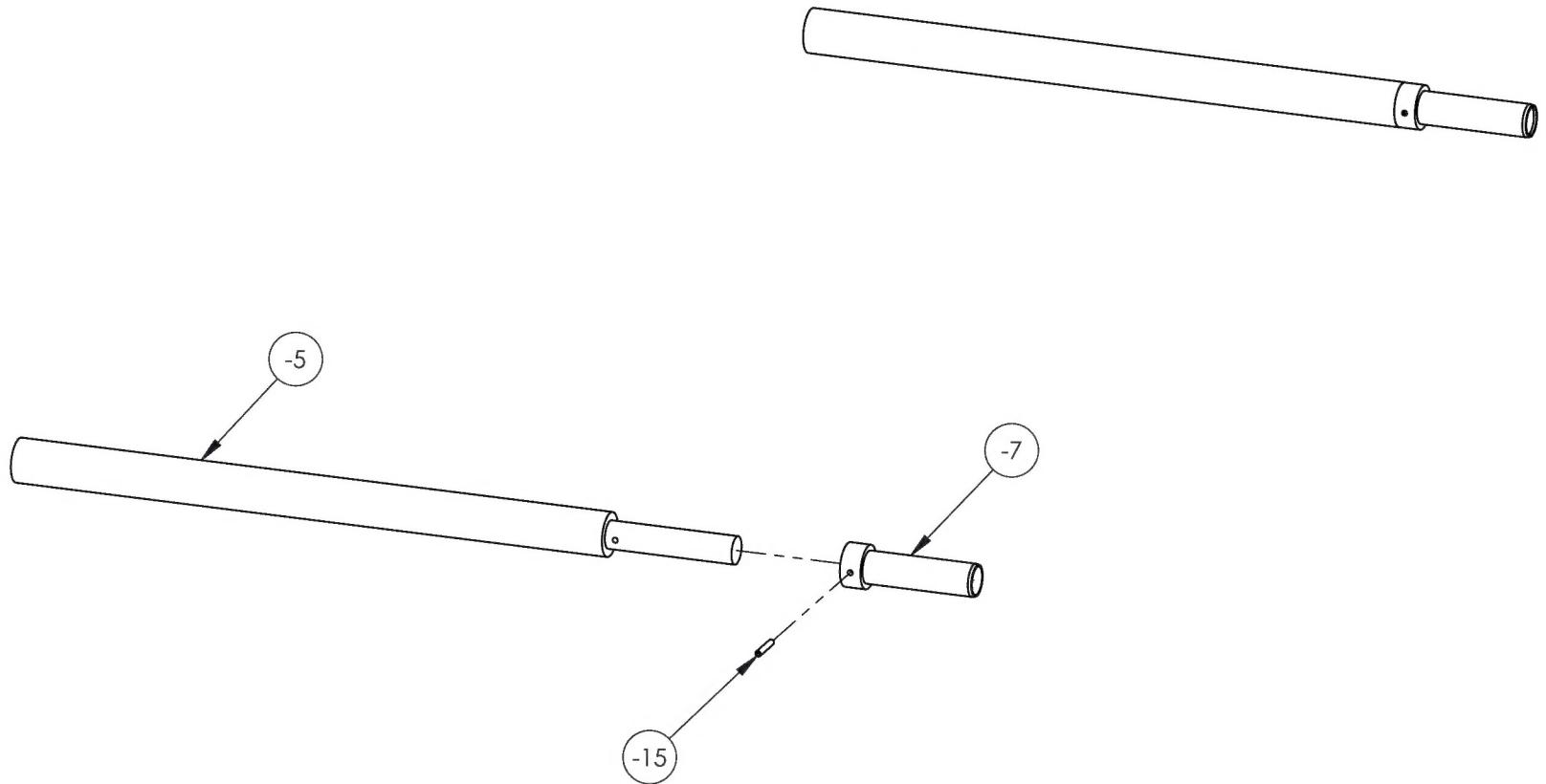
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
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<b>DART</b> AEROSPACE	
<b>TITLE:</b>	<b>SERVO-CONTROL FITTINGS NUT GUIDE</b>
<b>DWG NO.</b>	<b>RBEM632V3013101-1</b>
<b>REV</b>	<b>1</b>
<b>MATL:</b>	WHITE NYLON
<b>HEAT TREAT FINISH:</b>	UNLESS OTHERWISE SPECIFIED $.005 \pm .005$ FRACTIONS $\pm 1/8$ $.00 \pm .01$ ANGLES $\pm 5^\circ$ $\pm .1$ SURFACES = 125
<b>SPEC:</b>	
<b>DRAWN BY:</b>	DUERFELDT
<b>CHECKED:</b>	CLOUGH
<b>OPPS APPR:</b>	ANDERSON
<b>QA APPR:</b>	LINDSAY
<b>APPROVED:</b>	GILBERT
<b>USED ON MODEL</b>	H175
<b>SCALE</b>	1:2
<b>DATE</b>	6/14/2016
<b>SHEET</b>	2 OF 10

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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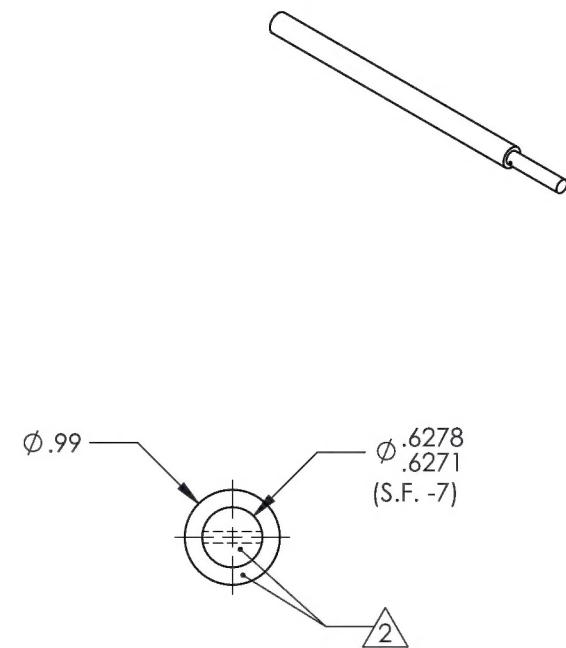
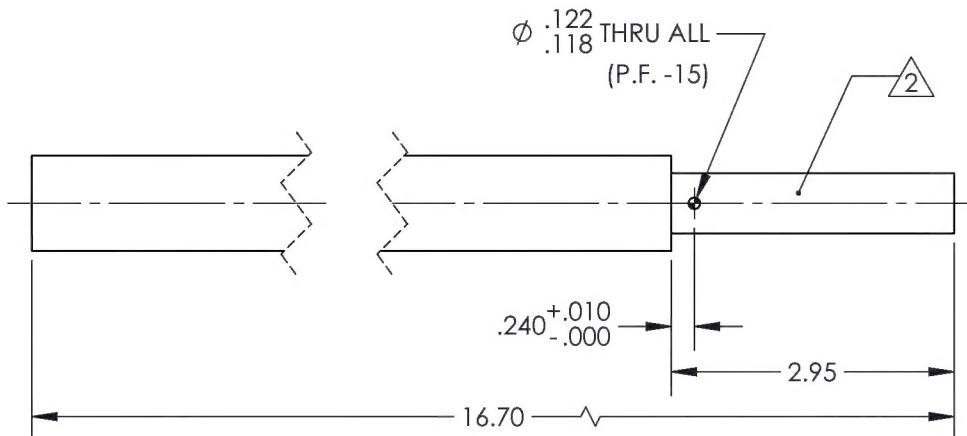


(-3)  
LOCK WRENCH

<b>DART</b> AEROSPACE	
TITLE <b>SERVO-CONTROL FITTINGS NUT GUIDE</b>	
DWG NO. RBEM632V3013101-3 REV 1	
MAT'L UNLESS OTHERWISE SPECIFIED HEAT DIMENSIONS ARE IN INCHES TREAT .XXX ± .005 FRACTIONS ± 1/8 FINISH .XX ± .01 ANGLES ± 5° SPEC X SURFACES = 125 ✓	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT H175
SCALE	1:4
DATE	6/14/2016
SHEET 3 OF 10	

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#### NOTES:

1. DUAL FINISH:  
1ST: ZINC PLATE, ASTM B633 TYPE I SC2.  
2ND: POWDER COAT YELLOW, FED #13538.

⚠ NO POWDER COAT THIS SURFACE.



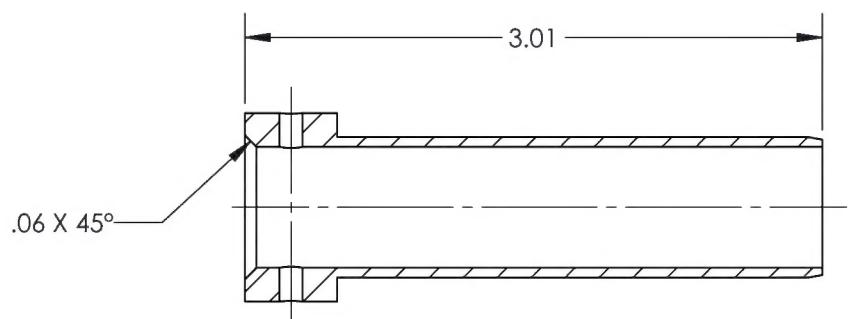
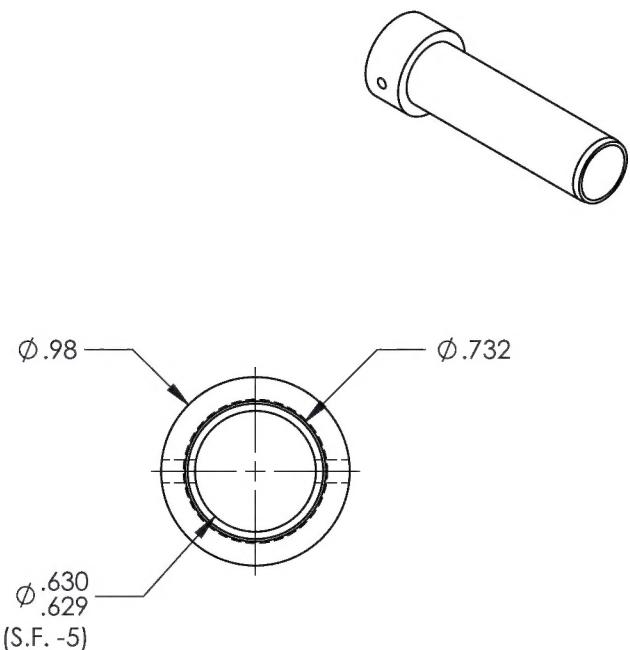
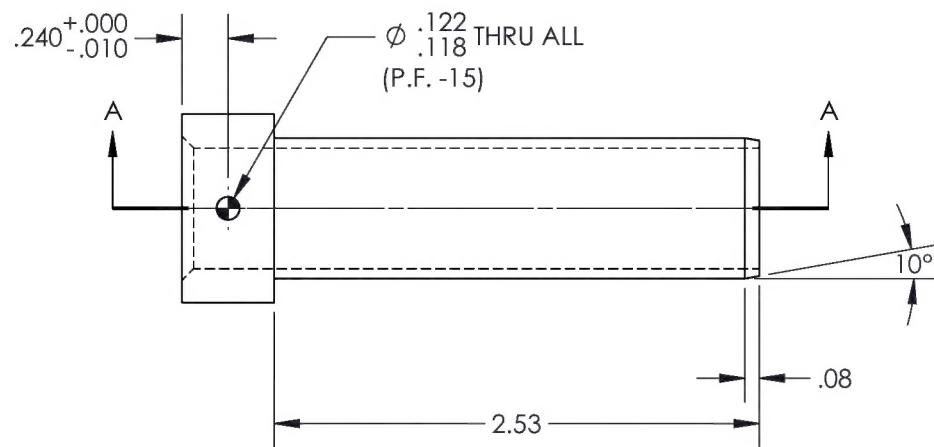
TITLE	
SERVO-CONTROL FITTINGS NUT GUIDE	
DWG NO.	RBEM632V3013101-5
REV	1
MAT'L 1018/1020 CR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH SEE NOTE 1	X ± .1 SURFACES = 125 ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	6/14/2016
SHEET 4 OF 10	

(-5)

ROD

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		DESCRIPTION	DATE	INITIAL APPROVED



SECTION A-A

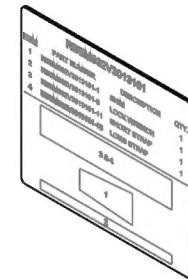
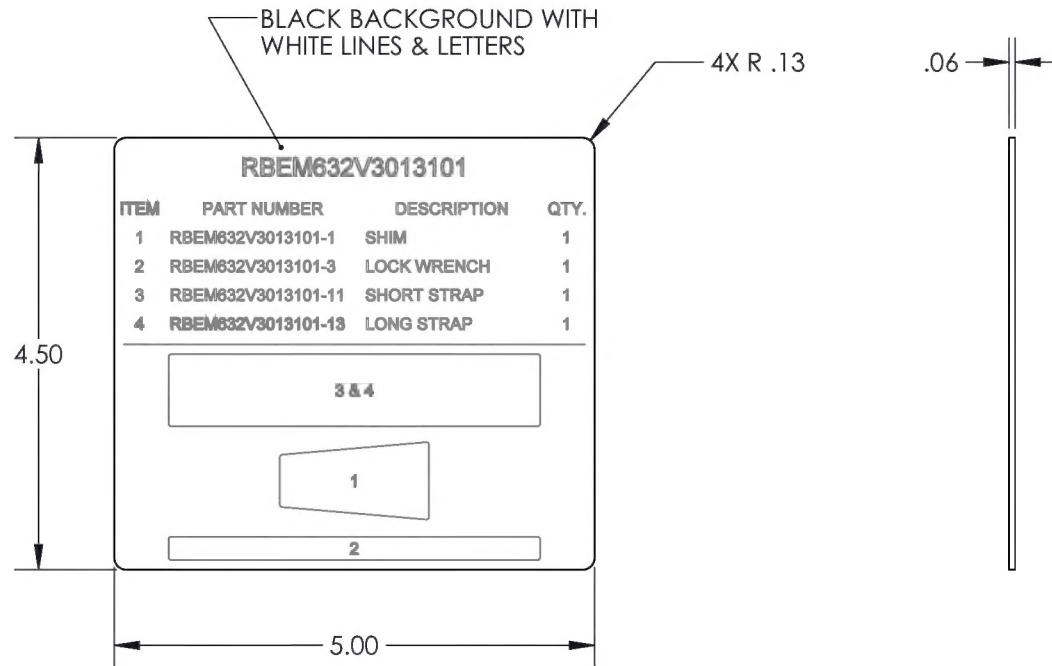
(-7)

COVER

<b>DART</b> AEROSPACE	
TITLE	
SERVO-CONTROL FITTINGS NUT GUIDE	
DWG NO.	RBEM632V3013101-7
REV	1
MAT'L 6061	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
X ± .1 SURFACES = 125 ✓	
SPEC MIL-A-8625F, TYPE II, CLASS I	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:1
DATE	6/14/2016
SHEET 5 OF 10	

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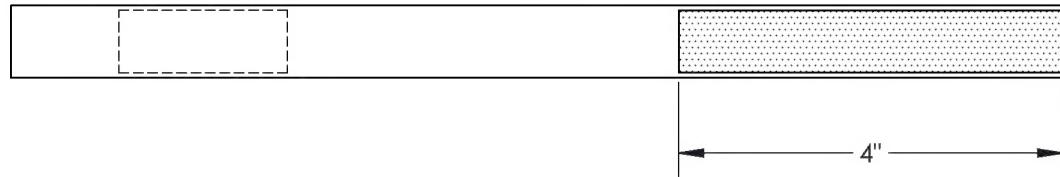
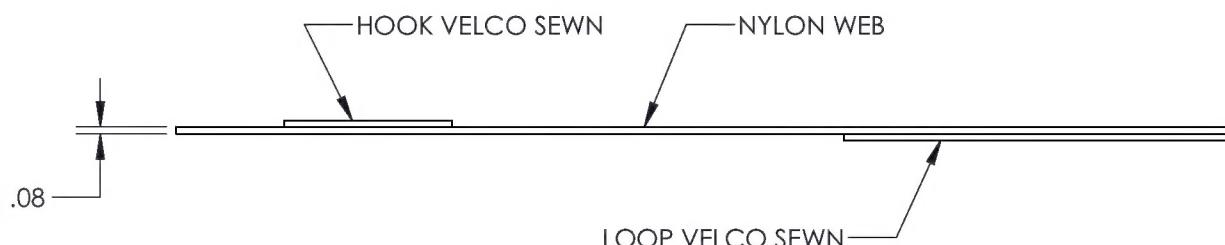
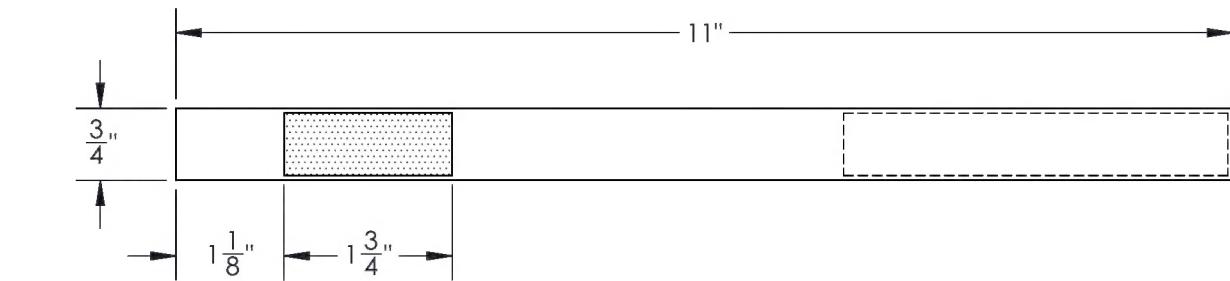
NOTE:  
USE PDF.



TITLE		SERVO-CONTROL FITTINGS NUT GUIDE	REV
DWG NO.	RBEM632V3013101-9		1
MATERIAL PLASTIC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .010	FRACTIONS ± 1/8
FINISH		.XX ± .03	ANGLES ± 1°
SPEC		X ± .1	SURFACES = 125 ✓
DRAWN BY:	DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	LINDSAY	USED ON MODEL	
APPROVED:	GILBERT	H175	
SCALE	1:2	DATE	6/14/2016
			SHEET 6 OF 10

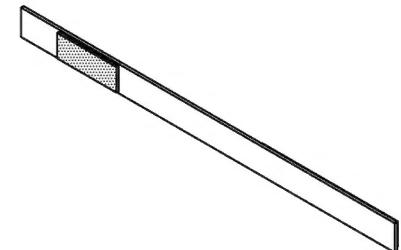
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(-11)

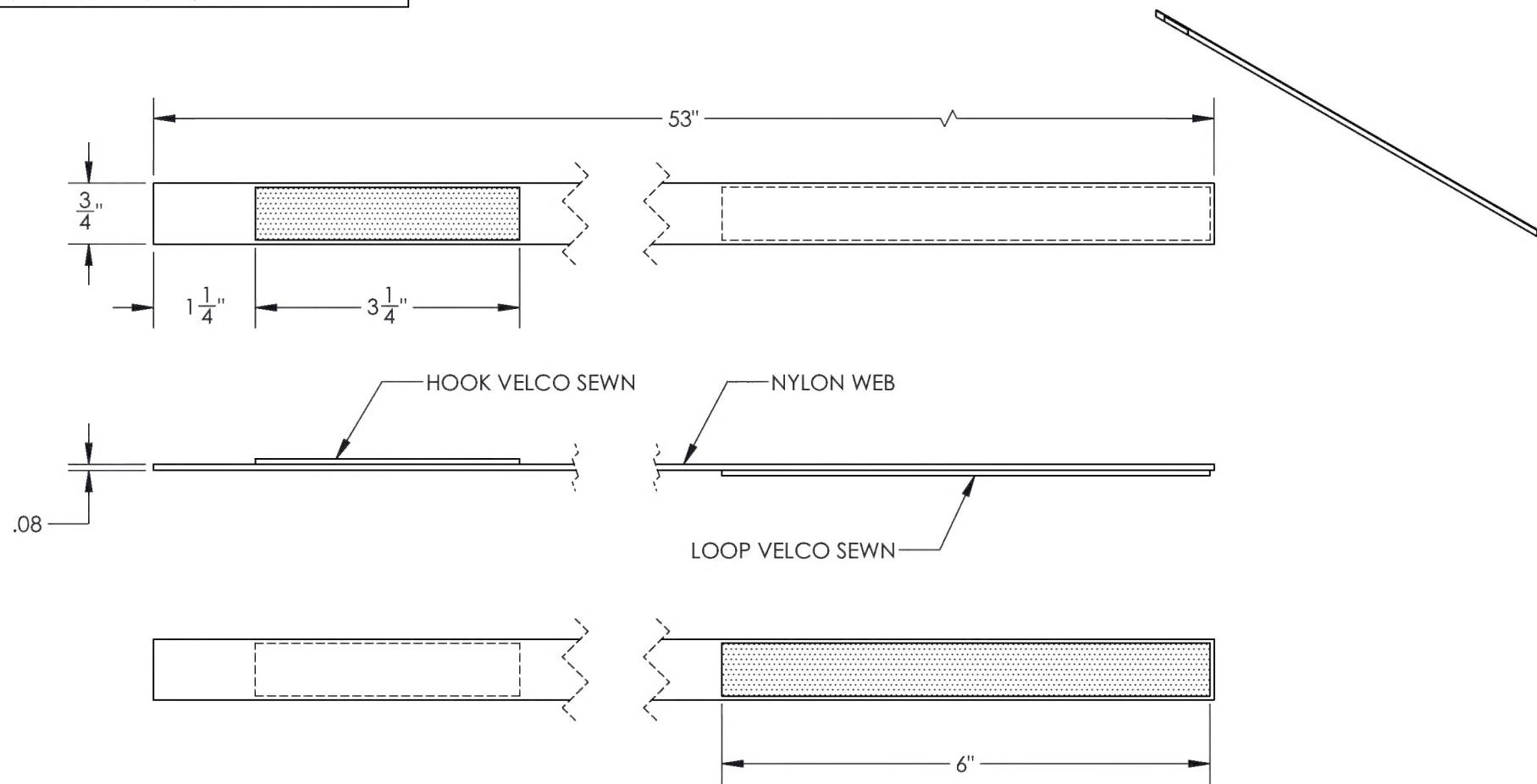
SHORT STRAP



<b>DART</b> AEROSPACE	
TITLE <b>SERVO-CONTROL FITTINGS NUT GUIDE</b>	
DWG NO. RBEM632V3013101-11 REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES HEAT .XXX ± .010 FRACTIONS ± 1/8 TREAT .XX ± .03 ANGLES ± 1° FINISH X ± .1 SURFACES = 125 ✓ SPEC	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT H175	
SCALE 1:2	DATE 6/14/2016
SHEET 7 OF 10	

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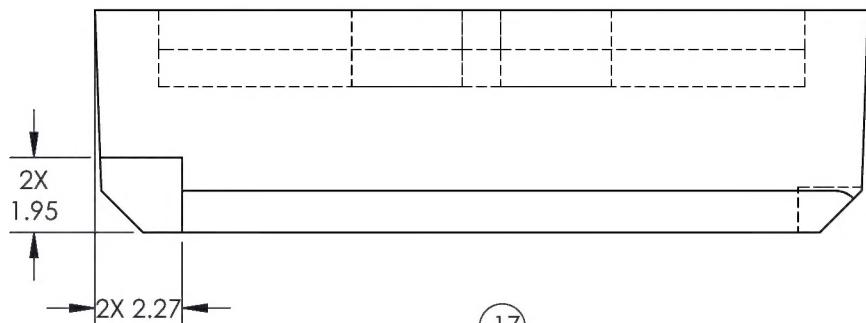
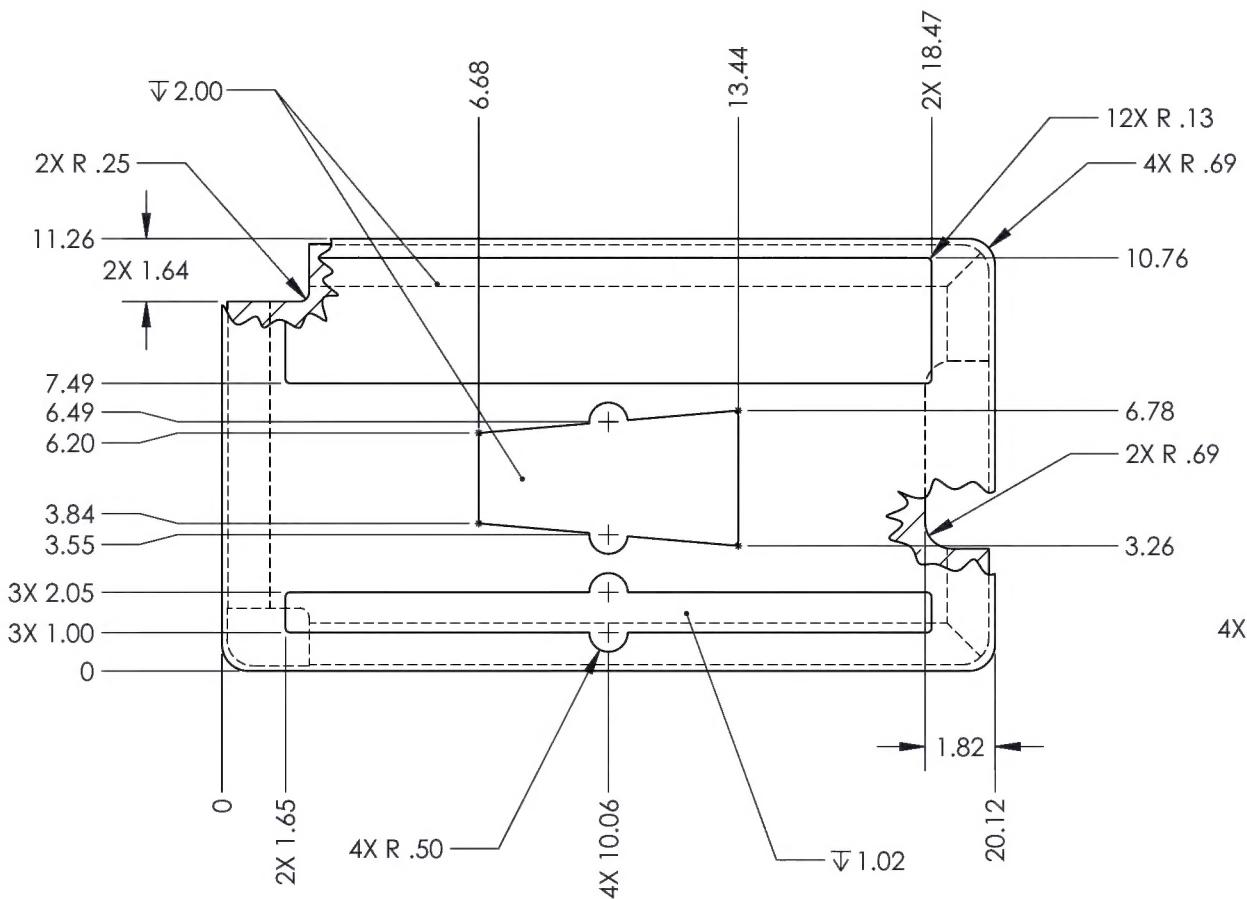
<b>DART</b> AEROSPACE																																					
TITLE <b>SERVO-CONTROL FITTINGS NUT GUIDE</b>																																					
DWG NO. RBEM632V3013101-13 REV 1																																					
<table border="1"> <tr> <td colspan="2">MAT'L NYLON</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>HEAT</td> <td>.XXX <math>\pm</math> .010</td> <td>FRACTIONS <math>\pm</math> 1/8</td> </tr> <tr> <td>TREAT</td> <td>.XX <math>\pm</math> .03</td> <td>ANGLES <math>\pm</math> 1°</td> </tr> <tr> <td>FINISH</td> <td>X <math>\pm</math> .1</td> <td>SURFACES = 125</td> </tr> <tr> <td>SPEC</td> <td colspan="2">1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY:</td> <td colspan="2">DUERFELDT</td> </tr> <tr> <td>CHECKED:</td> <td colspan="2">CLOUGH</td> </tr> <tr> <td>OPPS APPR:</td> <td colspan="2">ANDERSON</td> </tr> <tr> <td>QA APPR:</td> <td colspan="2">LINDSAY</td> </tr> <tr> <td>APPROVED:</td> <td colspan="2">GILBERT H175</td> </tr> <tr> <td>SCALE</td> <td>1:2</td> <td>DATE 6/14/2016</td> </tr> <tr> <td colspan="3">SHEET 8 OF 10</td> </tr> </table>		MAT'L NYLON		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	HEAT	.XXX $\pm$ .010	FRACTIONS $\pm$ 1/8	TREAT	.XX $\pm$ .03	ANGLES $\pm$ 1°	FINISH	X $\pm$ .1	SURFACES = 125	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		DRAWN BY:	DUERFELDT		CHECKED:	CLOUGH		OPPS APPR:	ANDERSON		QA APPR:	LINDSAY		APPROVED:	GILBERT H175		SCALE	1:2	DATE 6/14/2016	SHEET 8 OF 10		
MAT'L NYLON		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES																																			
HEAT	.XXX $\pm$ .010	FRACTIONS $\pm$ 1/8																																			
TREAT	.XX $\pm$ .03	ANGLES $\pm$ 1°																																			
FINISH	X $\pm$ .1	SURFACES = 125																																			
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																																				
DRAWN BY:	DUERFELDT																																				
CHECKED:	CLOUGH																																				
OPPS APPR:	ANDERSON																																				
QA APPR:	LINDSAY																																				
APPROVED:	GILBERT H175																																				
SCALE	1:2	DATE 6/14/2016																																			
SHEET 8 OF 10																																					

(-13)

LONG STRAP

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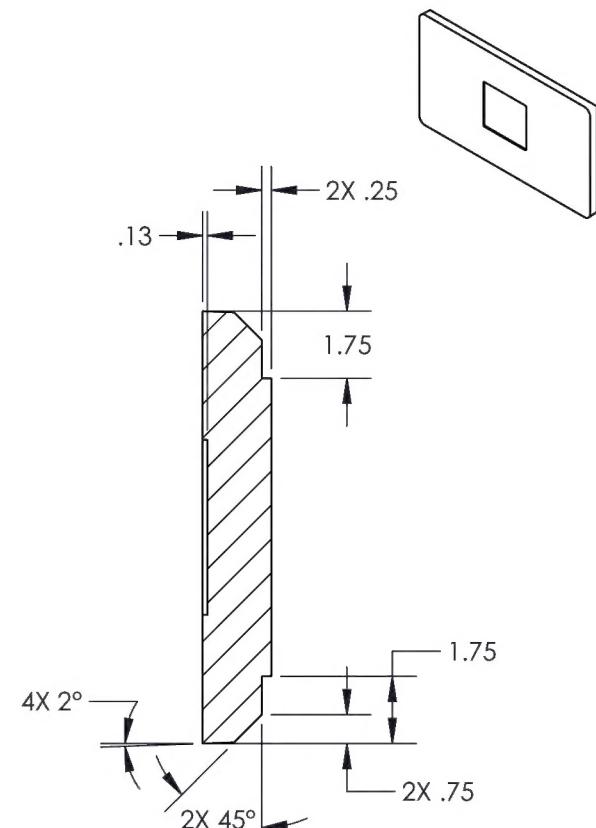
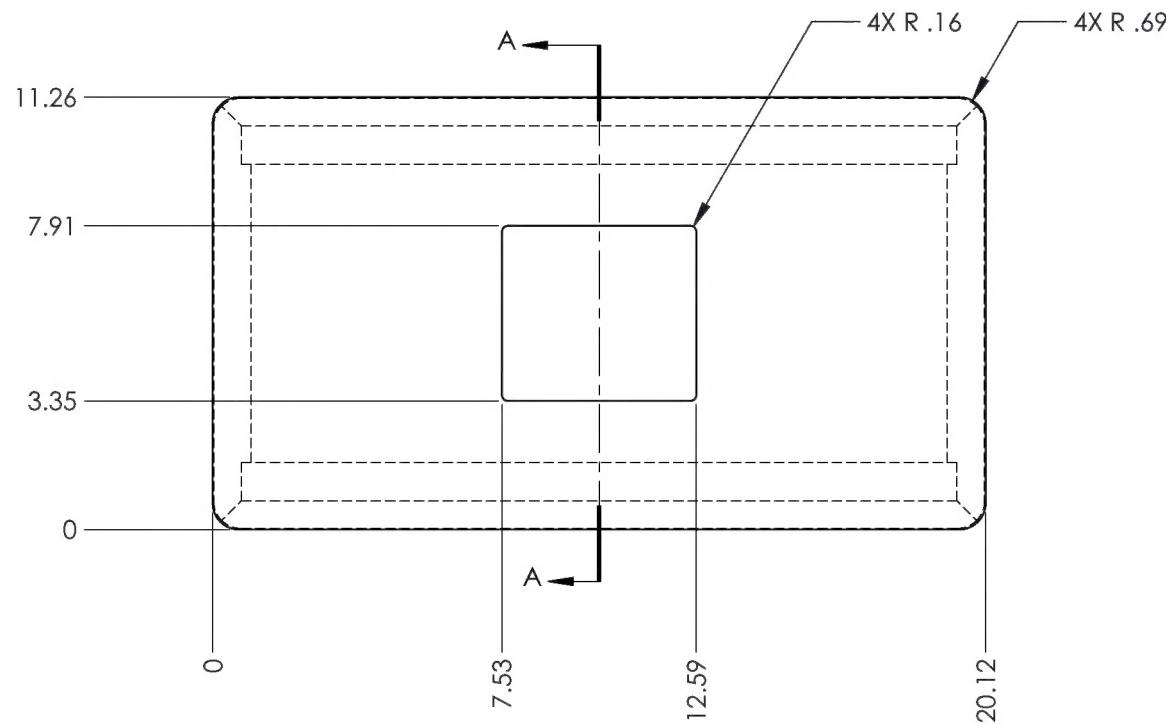
BOTTOM FOAM

(-17)

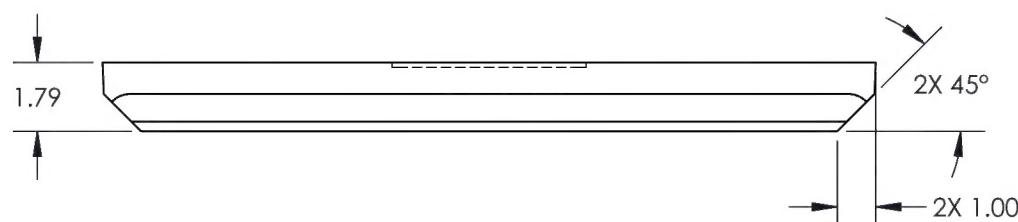
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TITLE <b>SERVO-CONTROL FITTINGS NUT GUIDE</b>	
DWG NO. RBEM632V3013101-17 REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT H175
SCALE	1:5
DATE	6/14/2016
SHEET 9 OF 10	

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SECTION A-A



TOP TOOL CUSHION

(-19)

DART AEROSPACE	
TITLE	
SERVO-CONTROL FITTINGS NUT GUIDE	
DWG NO.	RBEM632V3013101-19
REV	1
MATERIAL ETHAFOAM 220, BLACK	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	X ± .1 SURFACES = 125 ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:5
DATE	6/14/2016
SHEET 10 OF 10	